

85237

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 05/06/2012 **Start Qty:** 4.00

4

Customer:

Required Date: 19/06/2012 **Req'd Qty:** 4.00

4

Reference:

Approvals: Process Plan: MLJ Date: 12/06/05 Tooling:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
-----------------	---------------------

D3255 Rev. B

100 0.00

100

DOCUMENT CONTROL

DC

Memo

Document Control

Photocopy bluefile & type labels per PPPD412-705-017

CHG001

110	Pick Kit	0.00
-----	----------	------

110

Pick Kit

Packaging

Memo

Packaging

120	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

120

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85237

85237

Page 2

June-05-12 9:07:21 AM

Item ID: D412-705-017

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: N1 Gearbox Access Panel

Start Date: 05/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-705-017 Location: <u>FG 10</u> PPP Rev: <u>A</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

4 505 12/06/11

12/6/12

12-00-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-05-12 9:07:26 AM

Page 1

Work Order ID: 85237

85237

Parent Item: D412-705-017

D412-705-017

Parent Item Name: N1 Gearbox Access Panel

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C Removed Manufacturing 06-08-02 JLM
IPP Rev:D ECN 1052 07-11-06 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C3A		Purchased	No			120	Each	237.0000	30	120			
AN3C3A									**				
Bolt													

Location	Loc Qty	Loc Code
GA	70	
118352	70	
ST350	167	
120187	1	
121185	16	
121444	75	
121723	75	

D3255-041		Manufactured	No			120	Each	4.0000	1	4			
D3255-041									**				
Access Panel Assembly													

Location	Loc Qty	Loc Code
ST176	4	
79168	2	
83199	2	

D3255-042		Manufactured	No			120	Each	1.0000	1	4			
D3255-042									**				
Access Panel Assembly													

Location	Loc Qty	Loc Code
ST176	1	
78830	1	

B83200 12/6/88

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-05-12 9:07:26 AM

Page 2

Work Order ID: 85237

85237

Parent Item: D412-705-017

D412-705-017

Parent Item Name: N1 Gearbox Access Panel

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 4.00

Required Qty: 4.00

MS20427M3-3

Purchased

No

120

Each

1,601.000

36

144

MS20427M3-3

Rivet

Location

Loc Qty

Loc Code

GA

1363

121114

1363

ST318

238

120930

38

121350

200

MS21060-I 3K

Purchased

No

120

Each

209.0000

18

72

MS21060-I 3K

Nut Plate

Location

Loc Qty

Loc Code

302

100

121652

100

ST303

109

120142

95

121444

14

MS9321-09

Purchased

No

120

Each

412.0000

30

120

MS9321-09

Washer

Location

Loc Qty

Loc Code

ST296

412

119546

50

120142

2

120867

160

121524

200

June-05-12 9:07:26 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

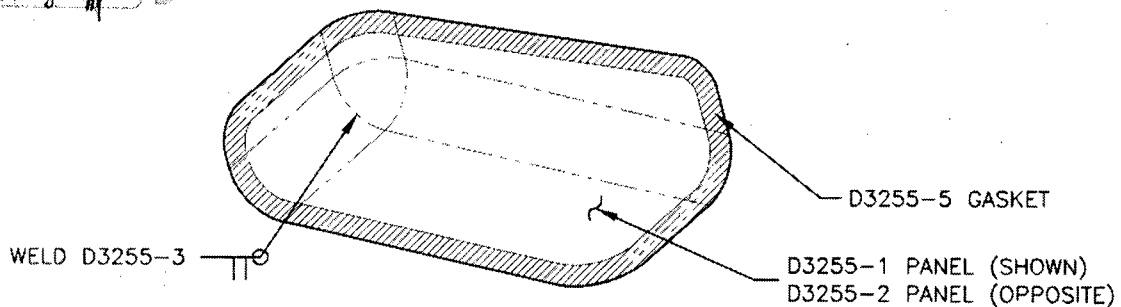
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

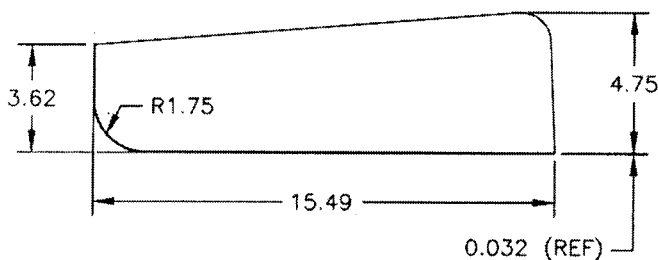
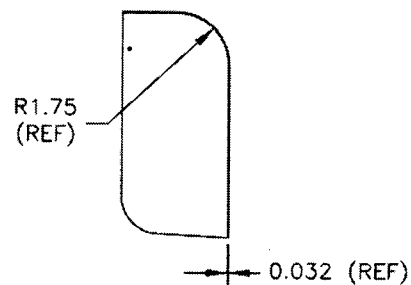
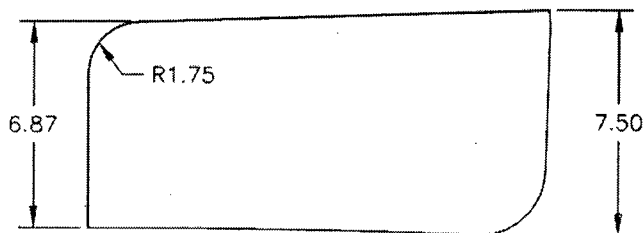


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED if	APPROVED #	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED
05-01-18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85257 MCT
12/06/05

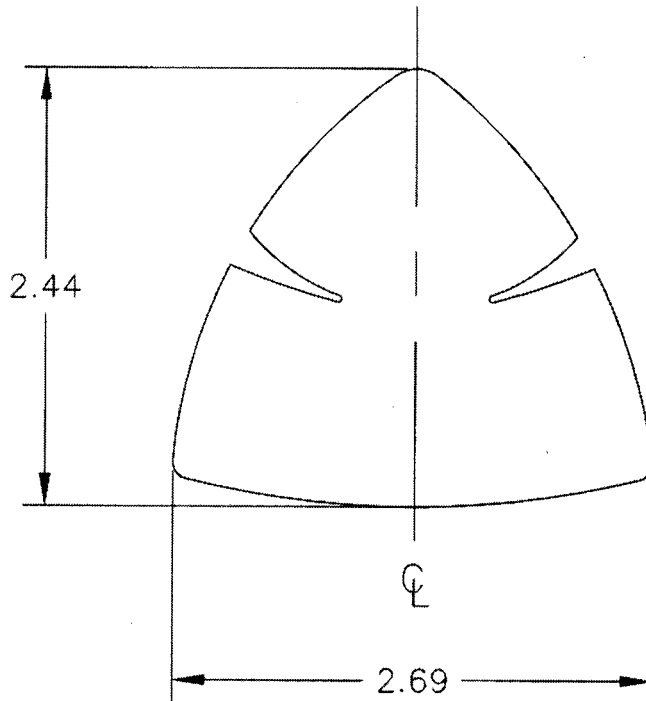
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DESIGN RF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 4P	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05.01.18



D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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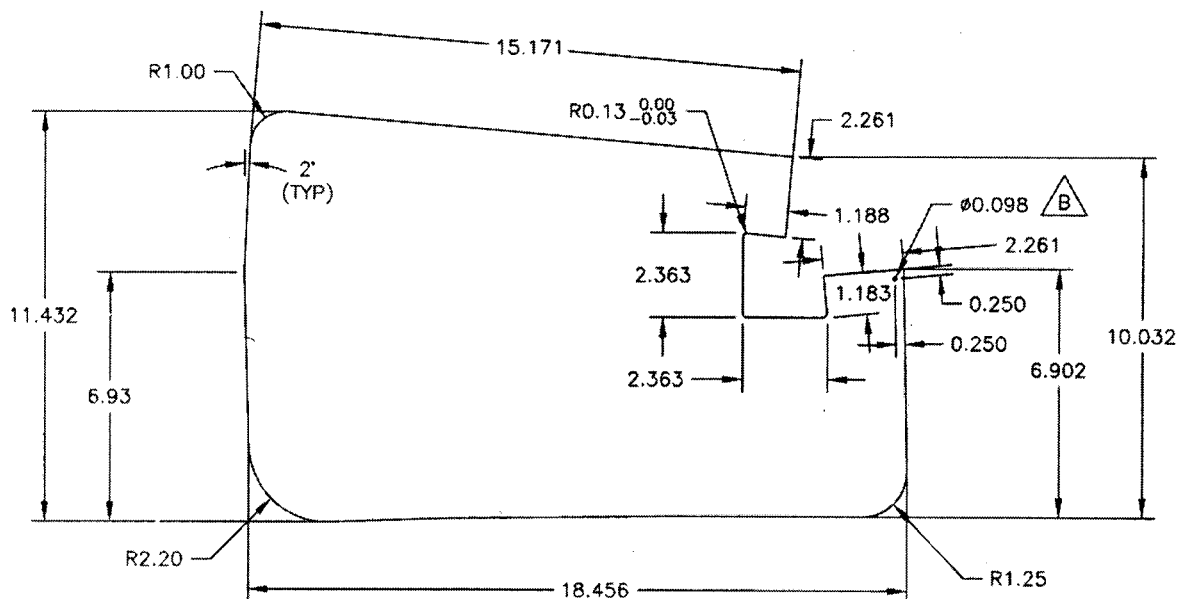
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05237



DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED H	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05 01 18



D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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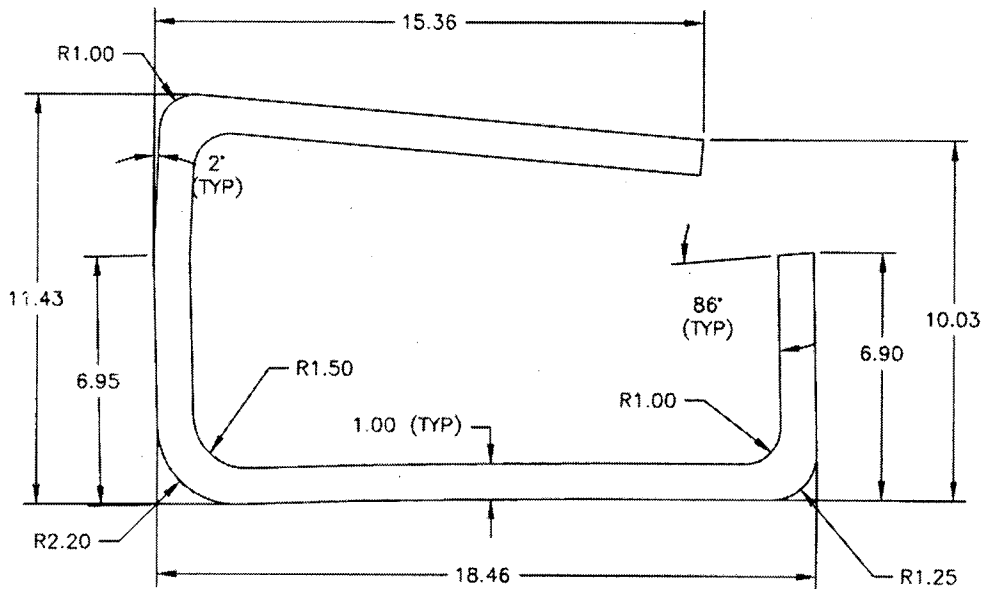
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DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05 01 18 JF



D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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85237

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
	1						D3245-041	ACCESS PANEL ASSEMBLY, LH
	1						D3245-042	ACCESS PANEL ASSEMBLY, RH
	2						D3245-043	DOOR ASSEMBLY
	2						D3245-9	GASKET
	2						D3245-11	GASKET
	2						D3245-13	GASKET
			1				D3255-041	ACCESS PANEL ASSEMBLY, LH
			1				D3255-042	ACCESS PANEL ASSEMBLY, RH
		1					D3256-1	ACCESS PANEL
		1					D3256-3	GASKET
				1			D3259-041	ACCESS PANEL ASSEMBLY, LH
				1			D3259-042	ACCESS PANEL ASSEMBLY, RH
					1		D3307-041	ACCESS PANEL ASSEMBLY
						30	AN3-3A	BOLT
		22	30		6		AN3C-3A	BOLT
	3						AN3C-4A	BOLT
						30	AN960JD10	WASHER
16	44	36			12		MS20427M3-3	RIVET
						2	MS21051-L3K	NUT PLATE
8	22	18			6		MS21060-L3K	NUT PLATE
						18	MS21069-L3K	NUT PLATE
	25	30			6		MS9321-09	WASHER

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Revision: C

Date: 07.10.12